

## CLAIMS

1. A method of forming by forging material, characterized in that the method comprises:

a first step of preparing sheet material, and

a second step in which a thickness of a circumferential portion of the material is made thinner than a thickness of a center portion of the material.

2. A method as claimed in claim 1, wherein the first step is a step of blanking sheet metal.

3. A method as claimed in claim 1, wherein the second step is a step of simultaneously stamping-forming a concavity in the center portion of the material.

4. A method as claimed in claim 1 or 3, wherein the second step is carried out by upsetting.

5. A method of forming a case, characterized in that the method comprises:

a first step of preparing sheet material, and

a second step in which a thickness of a circumferential portion of the material is made thinner than a thickness of a center portion of the material.

6. A method as claimed in claim 5, wherein the first step is a step of blanking sheet metal.

7. A method as claimed in claim 5, wherein the second step is a step of simultaneously stamping-forming a concavity in the center portion of the material.

8. A method as claimed in claim 5, wherein the second step is a step of forming by forging.

9. A method as claimed in claim 5, wherein the second step is carried out by upsetting.

10. A method as claimed in claim 5, further comprising a third step in which an intermediate product obtained by the second step is forward drawn to simultaneously form the peripheral wall and bottom of the case.

11. A method as claimed in claim 10, wherein, if  $\underline{a}$  is a thickness of the peripheral wall and  $\underline{b}$  is a thickness of the bottom,  $\underline{a} < \underline{b}$ .

12. A method as claimed in claim 5, wherein an intermediate product obtained by the second step is forward drawn to form a case peripheral wall, and then to form an internal boss.

13. A method as claimed in claim 5, wherein an intermediate product obtained by the second step is forward drawn to simultaneously form the case peripheral wall and the internal boss.

14. A method as claimed in claim 5, wherein an intermediate product obtained by the second step is annealed before being subjected to a subsequent step.

15. A method as claimed in claim 7, wherein the second step is a step of forming by forging.

16. A method as claimed in claim 7, wherein the second step is carried out by upsetting.

17. A method of forming a cup-shaped case having an internal boss, characterized in that the method comprises:

a step of preparing sheet material,

a step of making a thickness of a circumferential portion of the material thinner than a thickness of a center portion of the material and simultaneously stamping-forming a concavity in the center portion of the material, and

a method of forward drawing an intermediate product obtained by the stamping-forming to form a cup-shaped case having a bottom that is thicker than a peripheral wall.